

### CLASSIFICATION

EN ISO 2560-A : E 46 5 B 32 H5  
AWS A5.1 : E7018-1 H4

### GENERAL DESCRIPTION

L-7018 1 is a basic coated electrode. Weld metal has high impact strength at low temperatures. As the weld metal is very resistant to hot cracking, it is used particularly to weld rigidly restrained mass structures where high welding stresses are unavoidable. The slag is easy to remove and it gives very high quality, smooth weld beads. It has 125 % metal recovery.

### APPROVALS

CE, GOST, NAKS, SEPRO, TSE

ABS	BV	DNV	GL	LRS	RINA	RMRS	TL
3H5, 3Y	3YHHH	3YH5	3YH5	3m 3Ym H5	3YH5	3YHHH	3YH5

### CHEMICAL COMPOSITION (W%), TYPICAL, ALL WELD METAL

C	Si	Mn
0.07	0.50	1.20

### MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

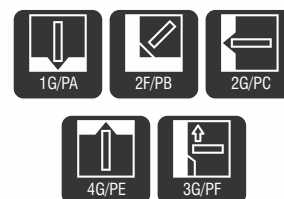
Yield Strength	: 480 N/mm <sup>2</sup>
Tensile Strength	: 580 N/mm <sup>2</sup>
Elongation (L=5d)	: 30 %
Impact (ISO-V)	: 180 J ( - 20°C) 120 J ( - 50°C)

Redrying Temperature : 350-400°C / 2-3 hrs

### WELDING PARAMETERS / PACKING AND DIAMETER INFORMATIONS / WELDING POSITIONS

Current Type and Polarity : DC (+) ; AC min 65 V

Diameter [ mm ]	Length [ mm ]	Current [ A ]	Electrode Weight [ g/100 pcs ]	Box Weight [ kg ] Quantity [ pcs/box ]	Export Box Box Weight [ kg ]
2.50	350	80 - 110	2460	2.2 / 90	5
3.25	350	110 - 145	3890	3.5 / 90	5
4.00	450	140 - 190	7310	6.6 / 90	6
5.00	450	180 - 240	10640	6.4 / 60	6



### APPLICATIONS AND MATERIALS TO BE WELDED

L-7018 1 is especially suitable for fine grained structural steels having high yield strength values. It is designed for steel constructions and machines operating under dynamic forces at low temperatures. Welding of ship's plate of A-, D- and E- quality, boiler and pressure vessel manufacturing and pipe connections are among its application areas. L-7018 1 can join steel parts to steel casts and can be used in the welding of thick parts. It is suitable for the root pass and welding in difficult positions. It gives excellent weld beads with high impact strength values at subzero temperatures.

	DIN	EN
<b>General Structural Steels</b>	St 33, St 34, St 37, St 44, St 44-2, St 44-3, St 52 St 37-4, St 44-4, St 52-4 St 50-2, St 60-2, St 70-2 C 60, Ck 60	S185, S235, S275, S355 P235TR2 - P355T2 E295, E335, E360 C60
<b>Fine Grained Steels</b>	StE 255 - StE 420 WStE 255 - WStE 420 TStE 255 - TStE 420	S255N - S420N P255NH - P420NH S255NL - S420NL / P275NL1 - P355NL1
<b>Pipe Materials</b>	StE 210-7 - StE 360-7 StE 290-7 TM - StE 360-7 TM - X42, X46, X52, X60 (API 5LX)	L210 - L360NB L290MB - L360MB L415NB -
<b>Boiler and Pressure Vessel Steels</b>	17 Mn 4, 19 Mn 6 H1, H11, H111	P295GH, P355GH P235GH, P265GH, P285NH
<b>Elevated Temperature Steels</b>	St 35-8, St 45-8	P235G1TH - P255G1TH
<b>Ship Plates</b>	A, D, E AH32 - EH36	- -
<b>Cast Steels</b>	GS-38, GS-45, GS-52, GS-60, GS-70 GS-62	GE200, GE240, GE260, GE300, S355J0C -

**Liability** : All information in this data sheet is based on the best available knowledge, is subject to change without notice and can only be considered as suitable for general guidance.  
**Fumes** : Consult information on Welding Safety Sheet, available upon request.

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